

Work Order ID 78871

78871

Page 1

January-16-12 4:26:51 PM

Item ID: D3564-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 16/01/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 30/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D Prog
 Rev: D 2-Debur if necessary

B 12-1-20

(14)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

B 12-1-20

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

51761120

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Large Fab	0.00							
150									
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch A/R 2059B Hardcoat								
	120480 Weld hardcoat as per Dwg D3437								

SB 12/01/23

S. 12/01/24

14

14

14x

ME. / EL. / 12/02/06 / 12/02/12

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
--	---	--------------	--	--	--	--	--	--	--

170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
--	---	--------------	--	--	--	--	--	--	--

180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 8:00 OVEN TEMPERATURE: FINISH TIME: 8:30	0.00 0.00							
---	---	--------------	--	--	--	--	--	--	--

W118489

3200F

8:30

14X6 m-12/02/09

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>FP-1</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

MLJ 12/02/09
 14

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Picklist Print

January-16-12 4:26:55 PM

Page 1

Work Order ID: 78871

78871

Parent Item: D3564-11

D3564-11

Parent Item Name: Wearshoe

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
 IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ
 Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	193.3300	1.41	17.81053			

M304S16GA

304/316 Sheet .063

**

1812-1-19

Location

Loc Qty

Loc Code

MAT020

193.33

119346

29.5

119653

67.83

120243

96

126243

(14)

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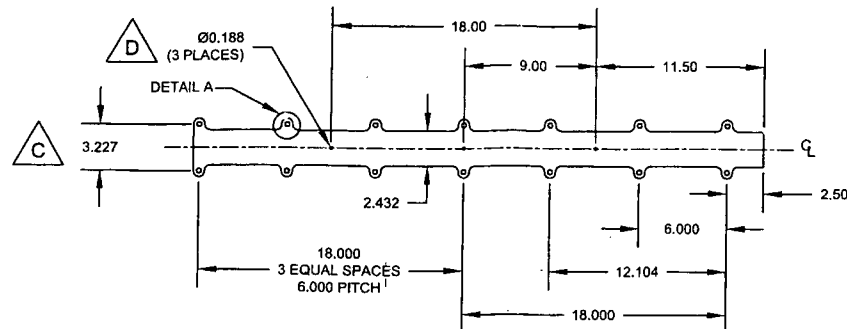
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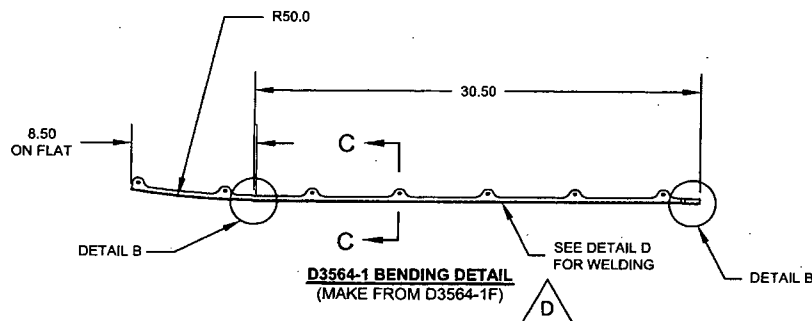
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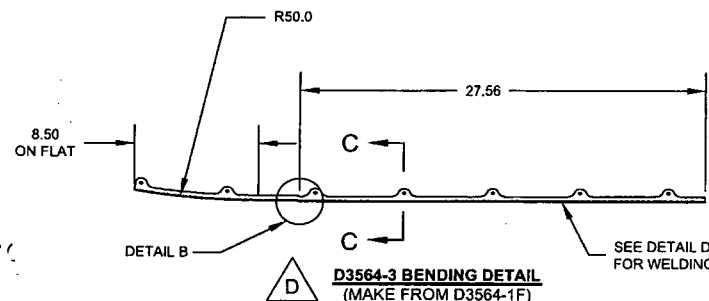
D3564-1F FLAT PATTERN

RELEASED

07.09.04



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

UNDER REVIEW
11/10/04
Frist change
OK 11/11/04

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

UNCONTROLLED
SUBMITTAL
DATE: 12/01/16

WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8; UPDATE NOTES; PG1 A8, PG3 B5,C5; ADD D3564-15; PG1 B6,B3; D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3; D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3; D3564-9/-11 WAS ON PG1; PG3 B8,C8; D3564-13 WAS ON PG2; PG3 D2; WELDING DETAIL WAS ON PG1 PG3 A5,7,B2; RELOCATE DETAILS AND SECTION; PG3 A5,7,B2; INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3564 TITLE WEARSHOE SCALE 1:8 REV. D SHEET 1 OF 3 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
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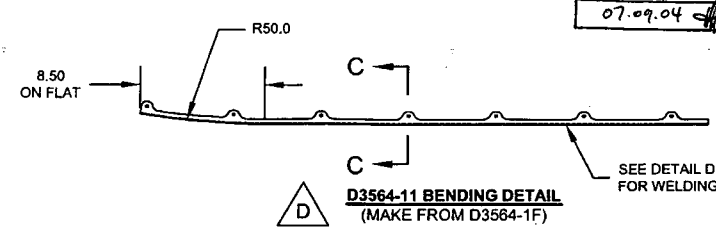
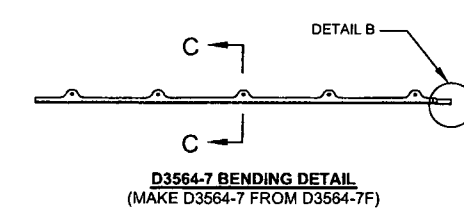
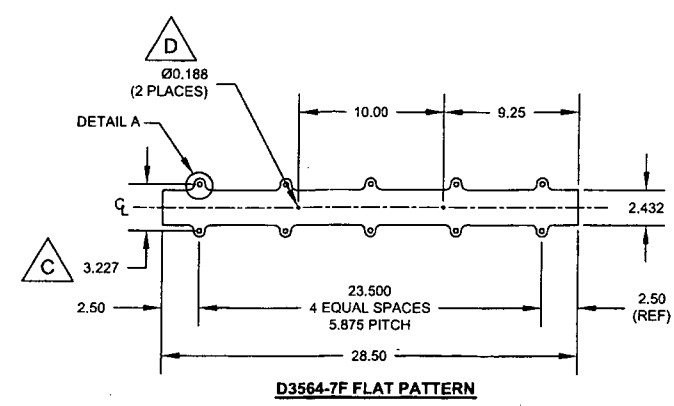
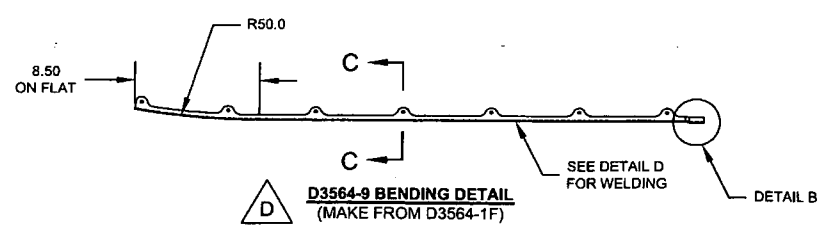
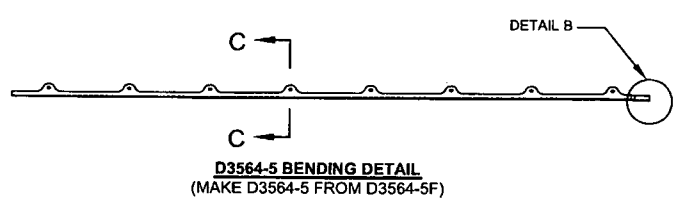
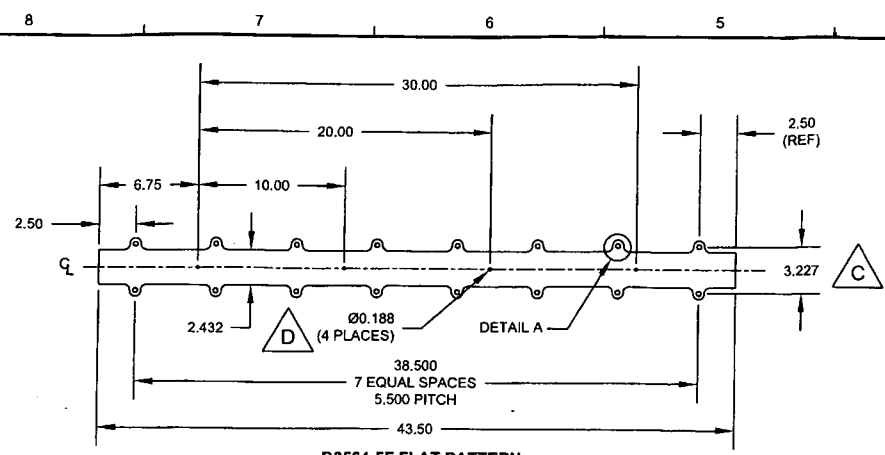
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NOTE: Date & initial all entries

78071



UNDER REVIEW
OK 07.11.28

RELEASED
07-09-04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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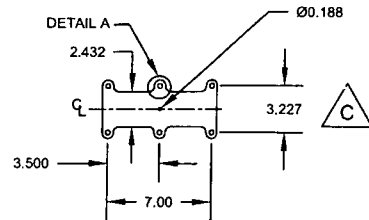
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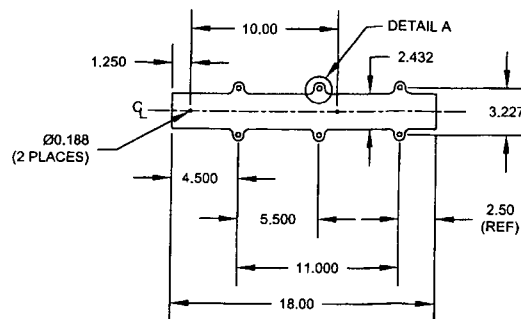
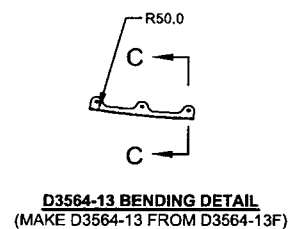
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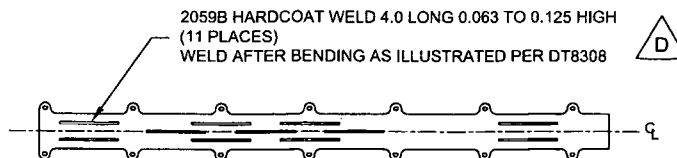
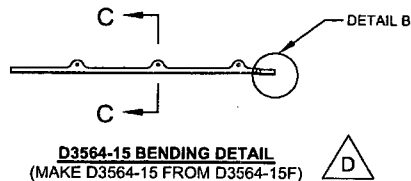
78871



D3564-13F FLAT PATTERN



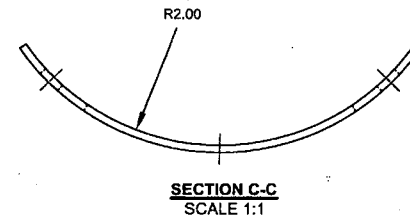
D3564-15F FLAT PATTERN



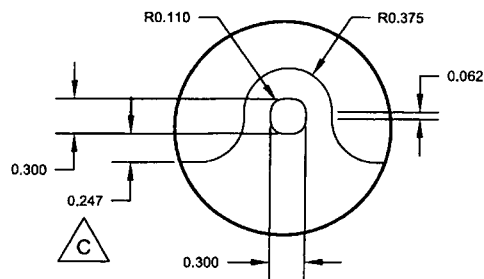
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED

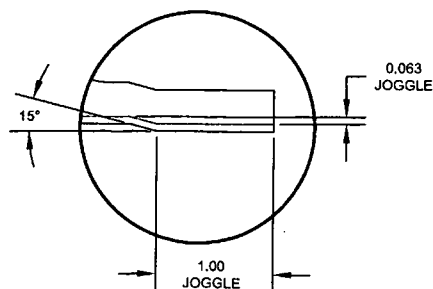
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

UNDER REVIEW
OK 07.11.28

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